

5/42

DART AEROSPACE LTD	Work Order:	24339
Description: Lever	Part Number:	D3122-1
Dwg: D3122 Rev. B	Qty:	10 U
Page 1 of 1		


Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	JP	05.09.26	10
2	PG	Issue P/O: <u>2008729</u> Email or ship Dxf file to vendor Laser Cut flat pattern as per Dwg D3122 Material: AISI 304/316 SS sheet 0.125" thick 11 gauge per MIL-S-5019 (Ref: Dart Spec. M304S) Annealed Material release note is required	JP	05/09/30	10
3	RG	Receive and Inspect for transit damage Ensure the material release note is attached.	CL	05/10/18	10
4	QC6	Inspect dimensions as per Dwg D3122	ml	05/10/26	10
5	GA	Deburr if necessary	ml	05/10/27	10
6	QC5	Inspect work to Step 5 ✓	JP	05.10.31	10
7	ST	Identify and Stock with part number and batch number using fine point permanent ink marker	ml	05/10/31	10
8	AC	Cost / part: <u>5.57</u>	S45	05.11.01	10
9	DC	Close W/O <u>4.95</u> Inspect Level 21	G	05/11/01	10

Rev	Date	Change	Revised By	Approved
A	04.11.29	New issue	KJ/RF	

RELEASED
05/11/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 05/11/01

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 26, 2005
10:48 am

Work Order No : 0024339
Project Name : D3122-1
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D3122-1
Description : Lever
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 09-26-05
Est Finish Date : 10-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods


	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



P41123PC002
 Certified in accordance to Pressure Equipment Directive 97/23/EC Annex I,
 Paragraph 4.3 by TÜV Anlagentechnik GmbH (Notified Body Identification No. 0035)
 Inspection Certificate EN10204-3.1B

ORIGINAL

Taiyuan Iron and Steel(Group)Co.,LTD NO.2 jiancaoping, Taiyuan, Shanxi, P.R.China TEL: (0351)3013328 FAX: (0351)3017816 http://www.tisco.com.cn E_mail: tgbxg@tisco.com.cn				INSPECTION CERTIFICATE							
				MATERIAL				AISI304 No.2B finish			
				SPECIFICATION				ASTM A240/A480 ASME SA240/SA480			
				L/C NO.							
				CERTIFICATE NO.				200412110			
				DATE OF ISSUE				/ /			
CUSTOMER				CONTRACT NO.				DATA OF			
Marubeni-Itochu Steel CA.				V-947				2004/12/20			
Product		Melting furnace		Inspectors stamp		Mark of the Manufacturer					
COIL		E+VOD				Shanxi Taiyuan Stainless Steel Co.,Ltd					
NO.	Heat No.	Coil No.	Quantity	Dimensions			Weight (kg)				
1	4405025	4A11-303-12B	1	11GA x 48 x C			4358				
2	4404509	4A10-356-12B	1	14GA x 48 x C			3920				
3	QHLL0164	4A12-141-3ZJ	1	14GA x 48 x C			4972				
4	Y408037	4A12-373-4ZD	1	12GA x 48 x C			4382				
5	Y408037	4A12-374-4ZD	1	12GA x 48 x C			4347				
6	Y408037	4A12-375-4ZD	1	12GA x 48 x C			4257				
7	4405608	4A12-341-1ZJ	1	12GA x 48 x C			3793				
Chemical Composition											
Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	N
4405025	0.060	0.470	1.340	0.020	0.002	18.050	8.100				0.059
4404509	0.050	0.470	1.350	0.021	0.002	18.080	8.120				0.060
QHLL0164	0.052	0.546	1.077	0.027	0.003	18.300	8.080				0.044
Y408037	0.063	0.550	0.980	0.030	0.002	18.320	8.170				0.060
Y408037	0.063	0.550	0.980	0.030	0.002	18.320	8.170				0.060
Y408037	0.063	0.550	0.980	0.030	0.002	18.320	8.170				0.060
4405608	0.060	0.510	1.350	0.021	0.002	18.090	8.100				0.055
Mechanical Properties											
Test No.	Tensile R _m N/mm ²	R _{p0.2} Yield _{0.2%} N/mm ²	R _{p1.0} Yield _{1.0%} N/mm ²	Elongation A5%	Corrosion Tests	Hardness					
						HRB	HV	HRC			
4405025-T	610	255		65		83					
4404509-T	655	265		61.5		84					
QHLL0164-T	660	275		58.5		83					
Y408037-T	660	260		64		85					
Y408037-T	660	260		64		85					
Y408037-T	660	260		64		85					
4405608-T	665	265		61.5		84					
Surface and dimensions controlled:											
Work Inspector: 